

304 R1.00



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D3009-3**Job Sheet 215054****Part No:** D3009-3**Job Qty:** 60 pcs**Part Name:** Cup**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/5/20**Job Tracking No:****Due Date:** 11/12/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	60 pcs	11/12/20	11/12/20	0.50	4.00	Hardinge - 1		<i>[Signature]</i> 20/11/20
120	QC 8	60 pcs	11/12/20	11/12/20	0.00	0.00	QC 8 - 12		<i>[Signature]</i> 20/11/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		
							QC 8 - 82		

**Container No:** S311561**Part:** D3009-3**Job No:** 215054**Serial No/Batch:** S311561**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 11/08/20

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130 Packaging 3-1 - Stock - B4B 60 pcs	11/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	DAS
			Packaging 3 - 12 - B4B	50 11-9-20
			Packaging 3 - 13 - B4B	9-89
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
140 QC 21 - SA 60 pcs	11/12/20	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	DAS
			QC 21 - SA - 9	21
			QC 21 - SA - 77	9-89
			QC 21 - SA - 28	

Part Op 100 - (Hardinge)1-TURN AS PER FOLIO FA130 & DWG D3009
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - Identify as per dwg & Stock Location: WA001-15. *****STOCK IN LARGE FAB*****
 140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	2.8740 ft (.0479 ea)	100-Hardinge - 1	5263839 5250477

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M304R1.000	3	5	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	.873 Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	.7515 Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	.266 Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	.06 Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084	.095 Diameter	
6	Cup	0.353Inches ± 0.010	0.363 0.343	.3535 Diameter	
7	Cup	0.063Inches ± 0.010	0.073 0.053	.06 Diameter	
8	Cup	0.032Inches ± 0.010	0.042 0.022	.03 Radius	
9	Cup	45.000Degrees ± 0.000	45.000 45.000	45 Angle	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					